

Cus:omer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	PIN ASSEMBLY	
Job Number	:	35441				
Estimate Number	:	11339				
P.O. Number	:	N/A	Part Number	:	D3332041	
This Issue	:	10/30/2007	S.O. No.	:	N/A	
Prsht Rev.	:	NC	Drawing Number	:	D3332 REV. A1	
First Issue	:	N/A	Project Number	:	N/A	
Previous Run	:	N/A	Drawing Revision	:	A1	
			Material	:	N/A	
Written By	:		Due Date	:	11/15/2007	Qty: 10
Checked & Approved By	:					Um: Each
Comment	:	Est: A 05.01.13 New issue KJ/JLM				

Job Number:



1.0	M1018R0500	1018-1025 Steel Bar
-----	------------	---------------------



Comment: Qty.: 0.3281 f(s)/Unit Total : 1.9688 f(s)  
1018-1025 Steel Bar  
Material: AISI 1018-1025 Ø0.500" Round Bar  
(M1018-R0.500)  
Identify for D3332-3  
Batch: M16634 DS 07/11/06

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



**Comment:** HARDINGE CNC LATHE SMALL  
Machine D3332-3 as per Folio FA493 and Dwg D3332

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0      QC8      SECOND CHECK



Comment: SECOND CHECK

5.0	M1018R0313	1018-1025 Steel Bar
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Comment: Qty.: 0.4594 f(s)/Unit Total : 2.7563 f(s)  
1018-1025 Steel Bar  
Material: AISI 1018-1025 Ø0.313" Round Bar  
(M1018-R0.313)  
Identify as D3332-5  
Batch: M16634 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/30/2007 2:49:05 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN ASSEMBLY

Job Number: 35441

Part Number: D3332041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
Fabricate D3332-5 as per Dwg D3332

*hd 07/11/20*

(10x)

7.0

D33321

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)  
Handle Assembly  
Pick:

Qty Part Number Description Batch  
1 D3332-1 Handle  
A/R N/A Steel Rod  
Identify as D3332-041

*323775 → 3 ✓ B 35 489 → 7 ✓  
M100372  
hd 07/11/20*

(10x)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
Assemble and Weld using D3332-041T1 as per Dwg D3332

*hd 07/11/20*

(10x)

9.0

QC3

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*QC#9 07/11/20 (10x)  
QC#5 07/11/20 (10x)*

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3  
Cover D3332-3 and cover thread only for D3332-5 prior to painting

*m 18052*

*FX 07/11/27 (10x)*

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*M. 07/11/27 (10x)*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: *ST 483*

*AS 07/11/28 (10x)*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 100 Date: 07/11/08

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/30/2007 2:49:05 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN ASSEMBLY

Job Number: 35441

Part Number: D3332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(18)

Comment: FINAL INSPECTION/W/O RELEASE

2011/12/20

Job Completion



W Bill 28

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

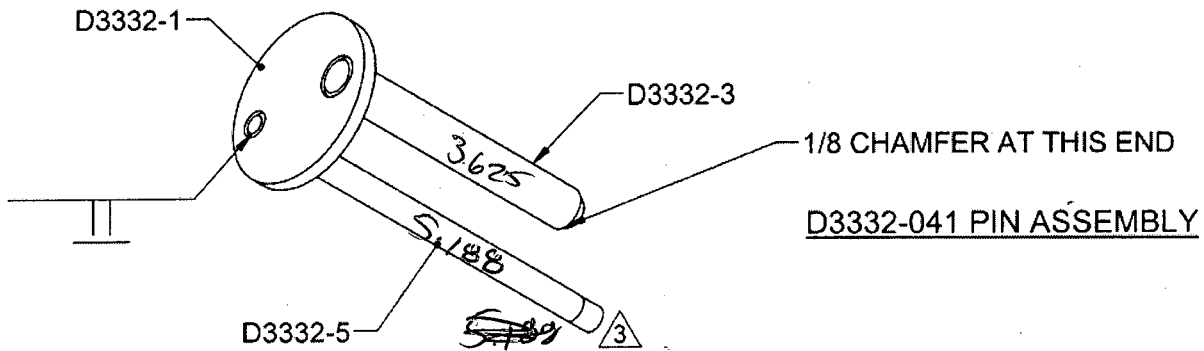
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

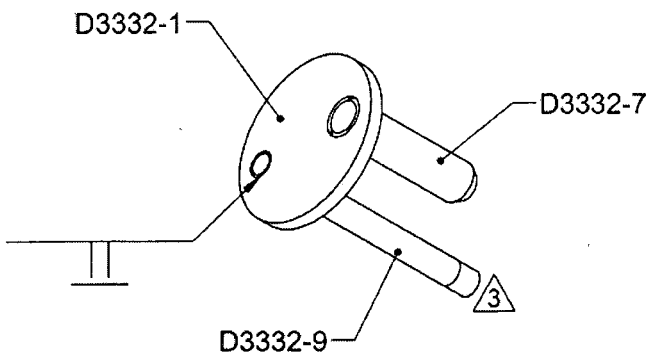
**NOTE:** Date & initial all entries

**DART**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3332</b>	REV. A SHEET 1 OF 4
DATE <b>04.12.14</b>		TITLE <b>PIN ASSEMBLY</b>	SCALE 1:2
A	04.12.14	NEW ISSUE	
A1	<i>[Signature]</i> 05.07.04	0.080 WAS 0.050; ADD TOLERANCE $\pm 0.000$ -0.005	



**RELEASED**  
*[Signature]*  
05/02/09

**NOTES:**

- 1) POSITION PARTS USING D3332-041T1
- 2) WELD PER DART QSI 004
- 3) MASK THREADS PRIOR PAINTING
- 4) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3  
(COVER THREAD ONLY FOR D3332-5/-9 PRIOR PAINTING)
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.10

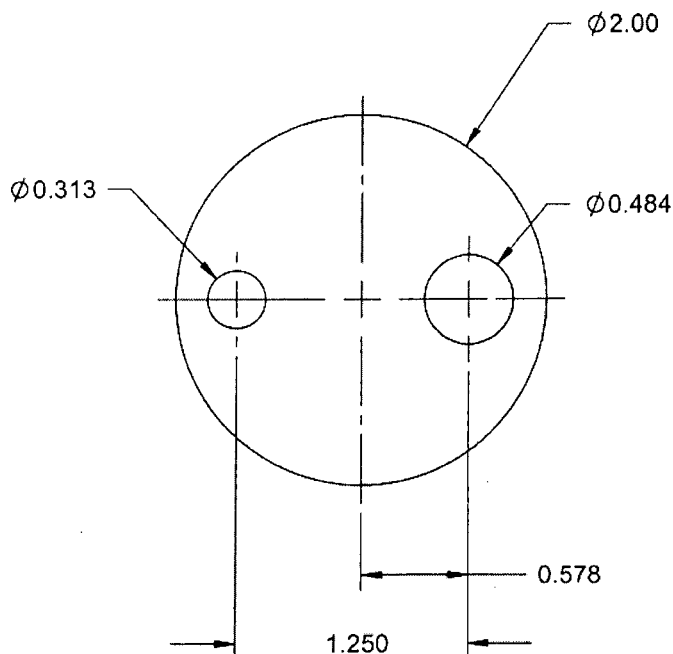
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DATE <b>04.12.14</b>		TITLE <b>PIN ASSEMBLY</b>	SCALE 1:1



**RELEASED**  
*MS*  
05/02/09

### D3332-1 HANDLE

#### NOTES:

- 1) MATERIAL: 1018-25 ROUND BAR STEEL PER MIL-S-7097  
(REF. DART SPEC. M1018-R2.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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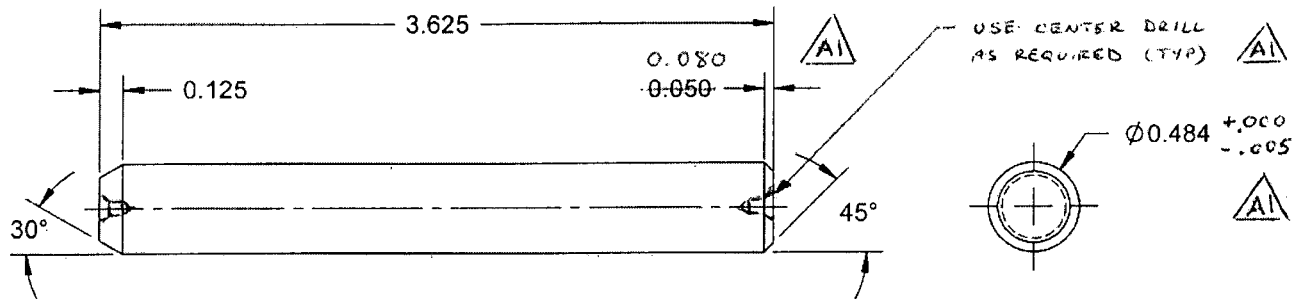
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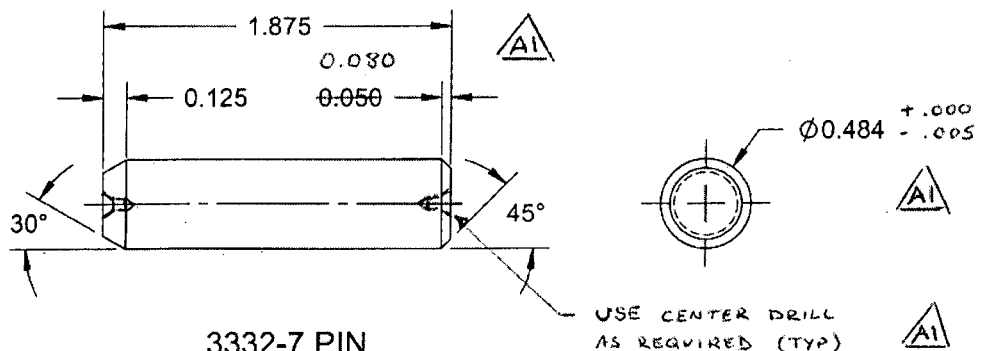


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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



3332-3 PIN

RELEASED  
*[Signature]*  
05/02/09



3332-7 PIN

**NOTES:**

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097 (REF. DART SPEC. M1018R0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

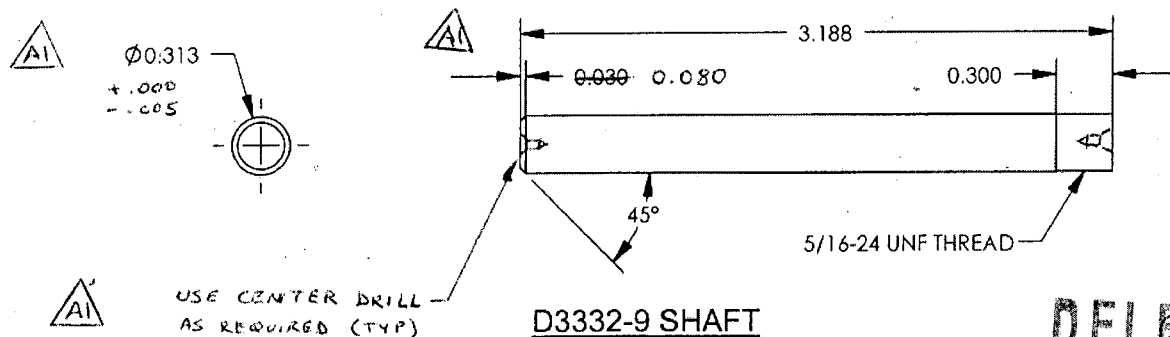
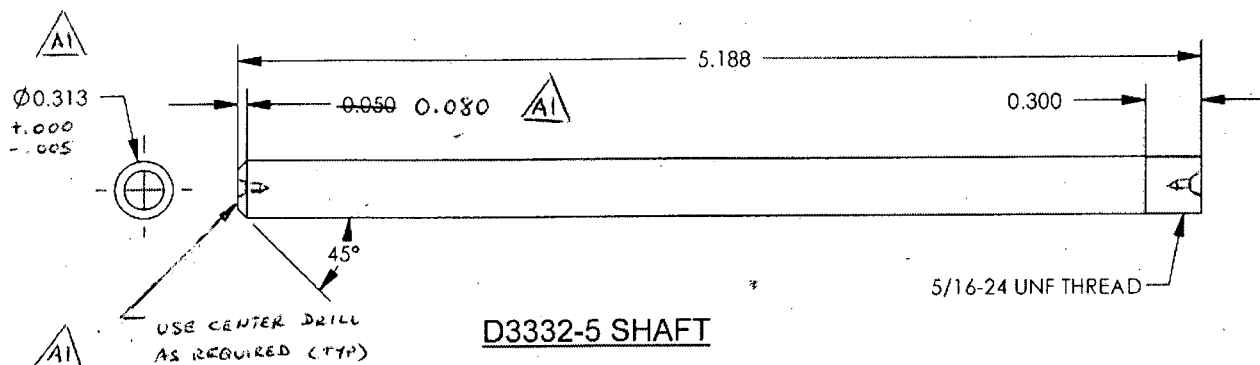
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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



RELEASED  
6/20/09

**NOTES:**

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097  
(REF. DART SPEC. M1018-R0.313)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES

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